

Work Order ID 128995

128995

Page 1

January 27-15 10:56:39 AM

Item ID: D3230-041 Accept ***N9000040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Basket Wedge Assembly
 Start Date: 1/27/15 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 1/30/15 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: W Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3230	Rev C

110 Large Fab 0.00

110

Large Fab

Large Fab

Memo

0.00

1-Cut 3/4 x 3/4 square tubing as per Dwg D3230
 2- Drill and c/sink holes
 3- cut mesh as per dwg
 4 -Deburr & Remove all Markings From Material
 5-Weld bushings and fabricate basket wedge assembly as per D3230
 LOOK AT DWG FRONT MESH MUST BE WELDED INSIDE
 A/R SS ROD Batch: 4130267

See only

120 QC9- Inspect visual per QSI004- Fusion Welds 0.00

120

QC

Quality Control

Memo

0.00

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Item ID: D3230-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Basket Wedge Assembly
 Start Date: 1/27/15 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 1/30/15 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130	QC5- Inspect part completeness to step on W/O	0.00							
130									
QC	Memo	0.00							
Quality Control									

140	White Gloss(Ref 4.3.5.1) per QSI005 4.3-Alum	0.00							
140									
Powdercoat	Memo	0.00							
Powder Coating									

Memo
 1ST COAT:
 START TIME: _____
 OVEN TEMPERATURE: _____
 FINISH TIME: _____

**** if necessary****

2ND COAT:
 START TIME: _____
 OVEN TEMPERATURE: _____
 FINISH TIME: _____

gus test fit

ENG 6/10/05

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Item ID: D3230-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Basket Wedge Assembly
 Start Date: 1/27/15 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 1/30/15 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC3- Inspect Part Finish	0.00							
150									
QC	Memo	0.00							
Quality Control									
180	Identify as per dwg & Stock Location: _____	0.00							
180	Packaging								
Packaging	Memo	0.00							
Packaging									
190	QC21- Final Inspection - Work Order Release	0.00							
190									
QC	Memo	0.00							
Quality Control									

Eds only

WLS05.08

Picklist Print

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Page 1

Work Order ID: 128995

128995

Parent Item: D3230-041

D3230-041

Parent Item Name: Basket Wedge Assembly

Start Date: 1/27/15

Required Date: 1/30/15

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:D 09-02-25 rev.c as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2232-3 *D2232-3* Basket Hinge		Manufactured	No			110	Each	36.0000	2	2			
** DAS 43 9-89 JAN 27 2015													
Location Loc Qty Loc Code													
WA004 36													
101778 16													
115847 20													
D2327-3 *D2327-3* Spacer Bushing		Manufactured	No			110	Each	46.0000	2	2			
** DAS 43 9-89 JAN 27 2015													
Location Loc Qty Loc Code													
WA004 46													
100523 25													
103679 21													
D3759-1 *D3759-1* Bushing		Manufactured	No			110	Each	194.0000	5	5			
** DAS 43 9-89 JAN 27 2015													
Location Loc Qty Loc Code													
WA004 194													
116816 182													
117449 12													
M304EX0.75-16F *M304FX0 75-16F* Expanded Metal Flat SS		Purchased	No			110	sf	422.0000	5.15	6			
**													
Location Loc Qty Loc Code													
WA006 422													
M131107 422													

B101778 → ~~4x~~
4x

B103679 → 2x

B117449 → 5x

Picklist Print

January-27-15 10:56:39 AM

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Work Order ID: 128995

128995

Parent Item: D3230-041

D3230-041

Parent Item Name: Basket Wedge Assembly

Start Date: 1/27/15

Required Date: 1/30/15

Start Qty: 1.00

Required Qty: 1.00

M304TS0.750W.065

Purchased

No

110 f

1,120.350 25.2966 27

M304TS0 750W 065

304 SQ Tube .75x.75x.065W

**

DAS

43

9-89

JAN 27 2015

4128495 → 29 Oct

Location

Loc Qty

Loc Code

WA004

1120.35

125513

14

m128495

506.35

m131206

600

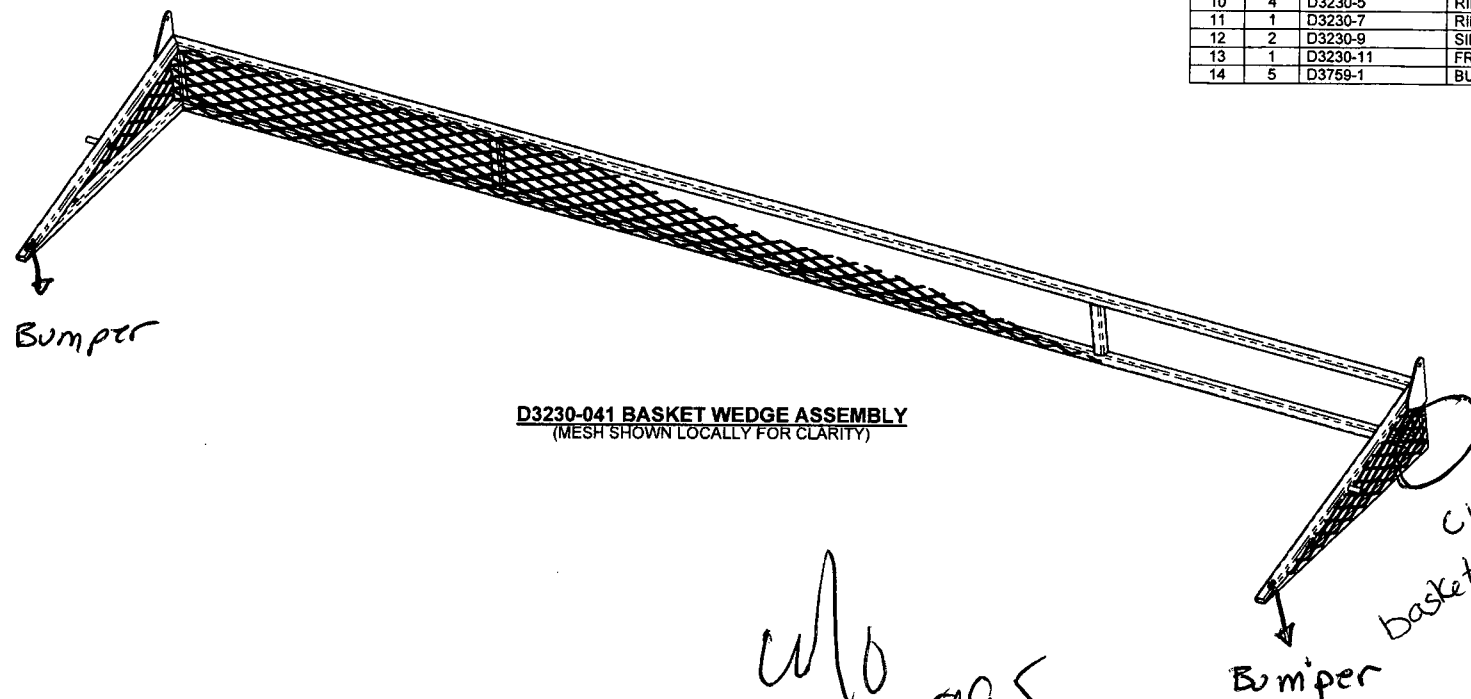
D 4021-9

QTY

4x

130981

ITEM	QTY	P/N	DESCRIPTION
1	X	D3230-041	BASKET WEDGE ASSEMBLY
3	1	D2221-1	RIB
4	2	D2232-3	BASKET HINGE
5	2	D2327-3	SPACER BUSHING
6	1	D3230-1	RIB
7	1	D3230-2	RIB
8	1	D3230-3	RIB
9	1	D3230-4	RIB
10	4	D3230-5	RIB
11	1	D3230-7	RIB
12	2	D3230-9	SIDE MESH
13	1	D3230-11	FRONT MESH
14	5	D3759-1	BUSHING

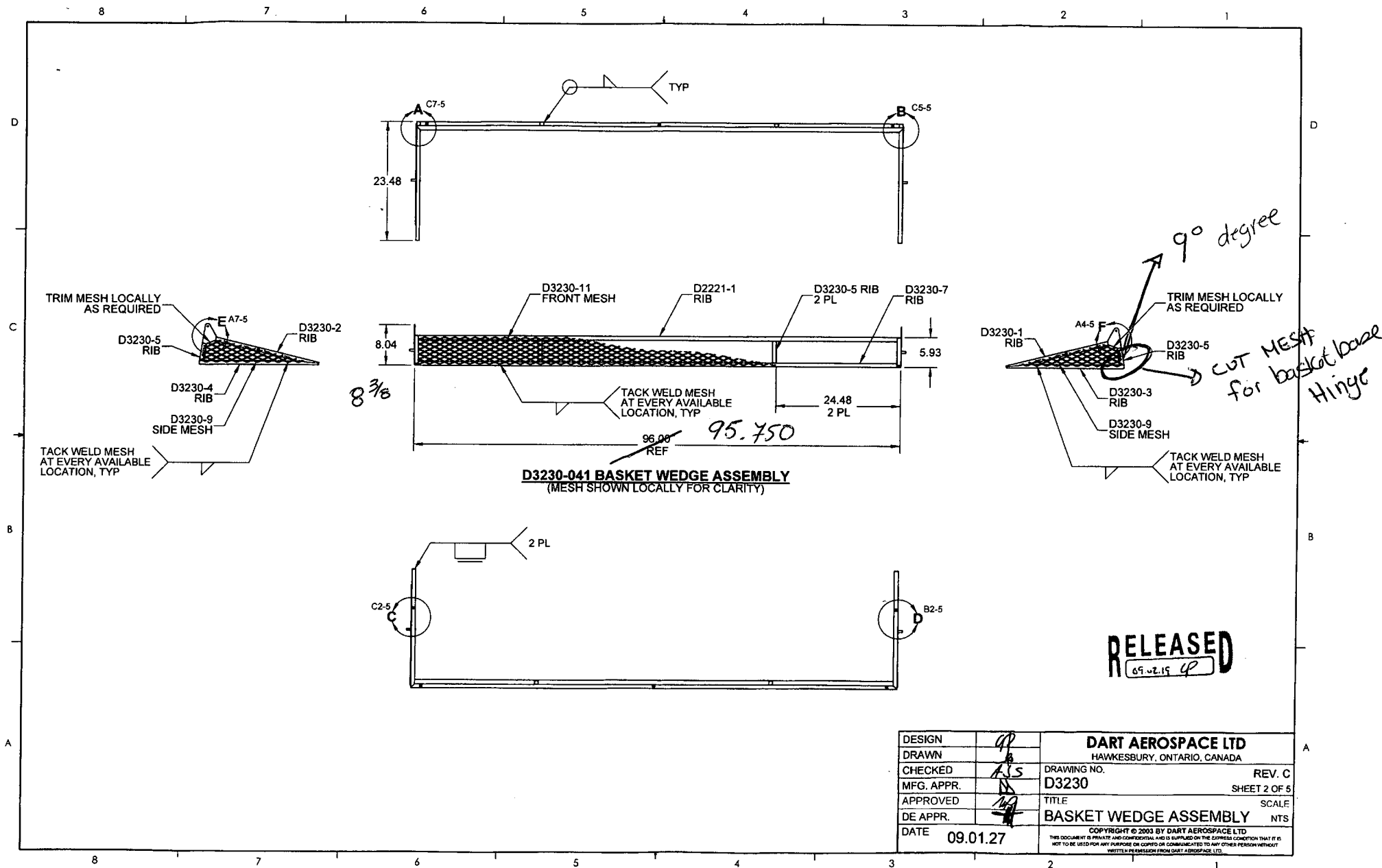


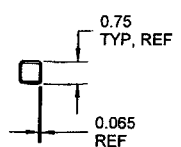
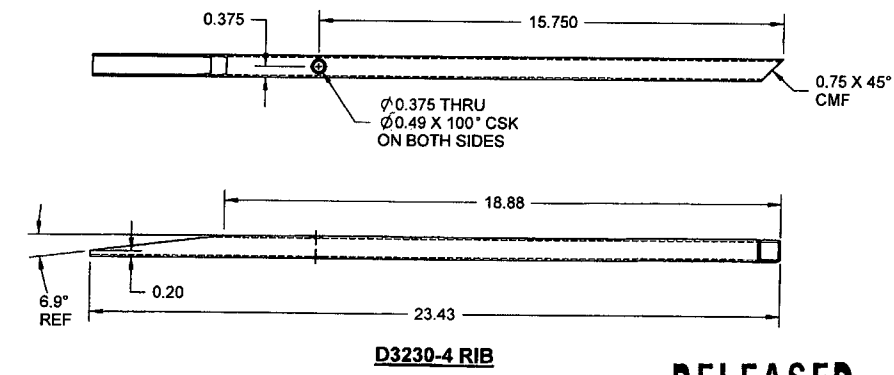
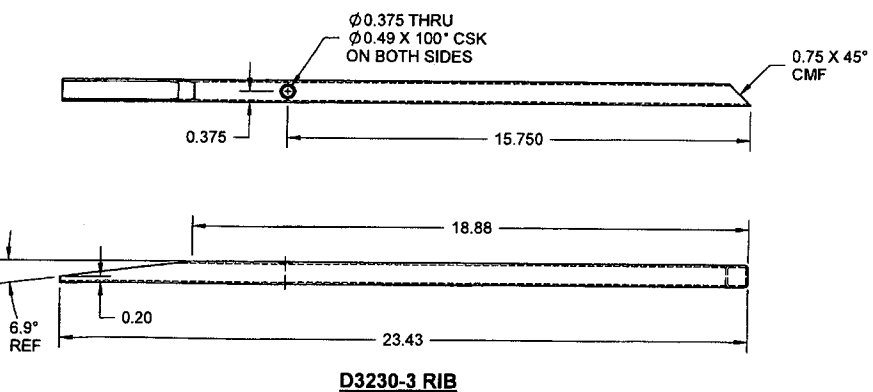
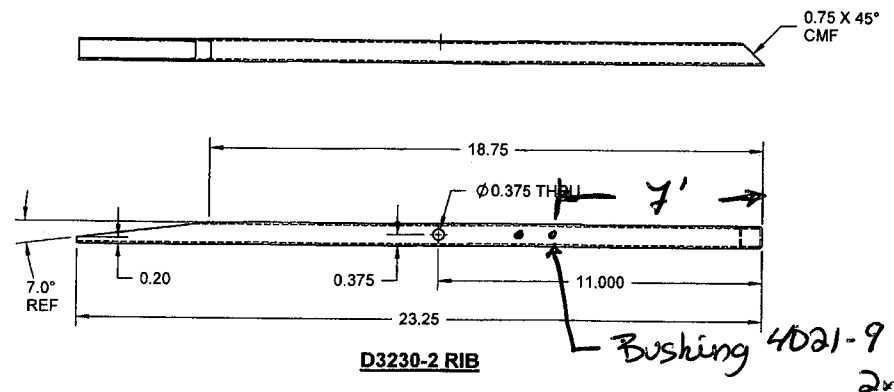
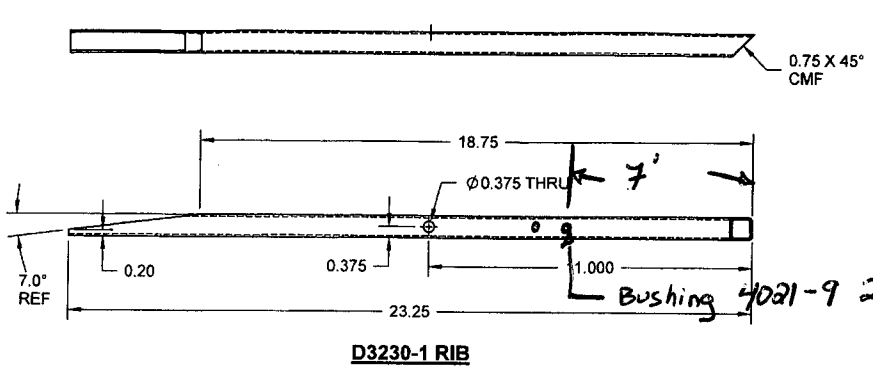
D3230-041 BASKET WEDGE ASSEMBLY
(MESH SHOWN LOCALLY FOR CLARITY)

RELEASED
09.02.19 CP
PER ECN 09-534

C	REDESIGN (SEE NCR 09-010); REFORMAT DRAWING TO CURRENT STANDARDS	MB	09.01.27
B	15.75 WAS 16.00; REMOVE D2581; ADD VIEW B-B; D2327-3 ADDED	CB	06.11.10
A	NEW ISSUE	CP	03.10.31
REV.	DESCRIPTION	BY	DATE
DESIGN	AP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AB		
CHECKED	AS	DRAWING NO.	REV. C
MFG. APPR.	AS	D3230	SHEET 1 OF 5
APPROVED	AS	TITLE	SCALE
DE APPR.	AS	BASKET WEDGE ASSEMBLY	NTS
DATE	09.01.27	COPYRIGHT © 2003 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

- NOTES:**
- 1) MATERIAL: N/A
 - 2) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3230-041" USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: 19.8 lbs
 - 8) WELDING: PER DART QSI 004

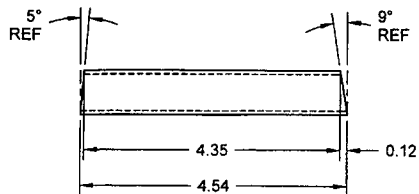




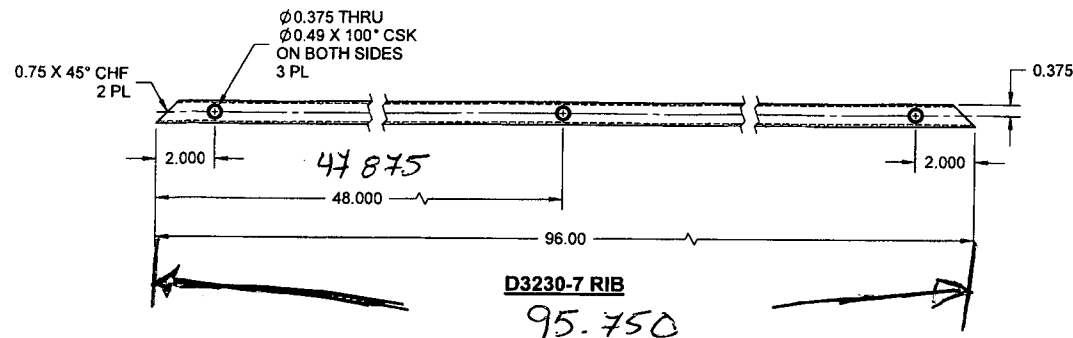
- NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL REF. DART SPEC. M304TS0.750W0.065
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 1.01 lbs EACH

RELEASED
09.01.19

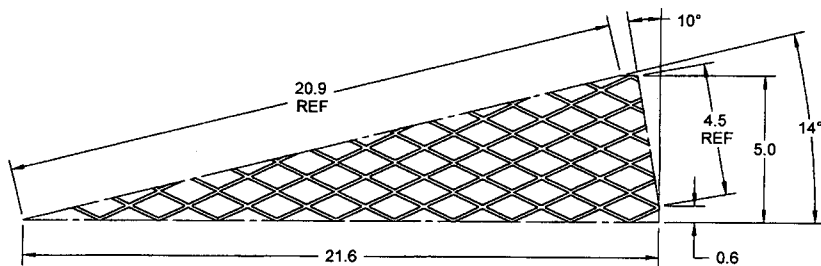
DESIGN	DP	DART AEROSPACE LTD	
DRAWN	AS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AS	DRAWING NO.	REV. C
MFG. APPR.	AS	D3230	SHEET 3 OF 5
APPROVED	AS	TITLE	SCALE
DE APPR.	AS	BASKET WEDGE ASSEMBLY	NTS
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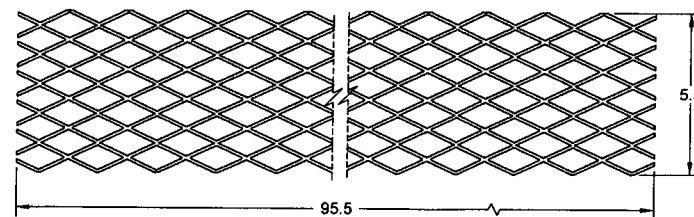
D3230-5 RIB



D3230-7 RIB



D3230-9 SIDE MESH



D3230-11 FRONT MESH

NOTES:

1) MATERIAL:

D3230-5/-7: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL
REF. DART SPEC. M304TS0.750W0.065
D3230-9/-11: 3/4-16F EXPANDED STAINLESS STEEL
REF. DART SPEC. M304EX0.75-16F

2) FINISH: N/A

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

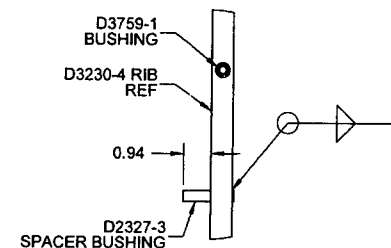
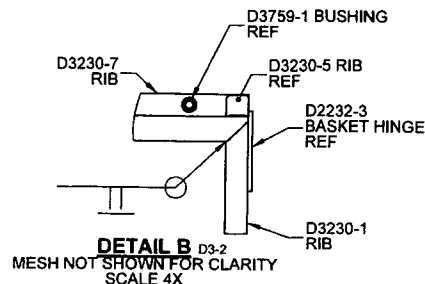
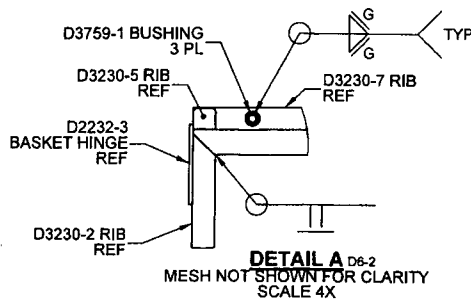
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: N/A

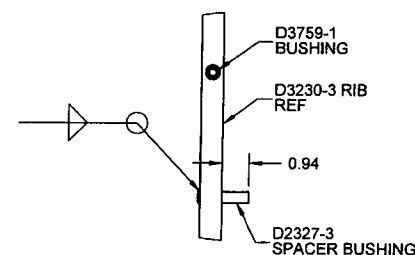
**7) WEIGHT: D3230-5 = 0.21 lbs; D3230-7 = 4.55 lbs
D3230-9 = 0.20 lbs; D3230-11 = lbs**

RELEASED
09-2-19

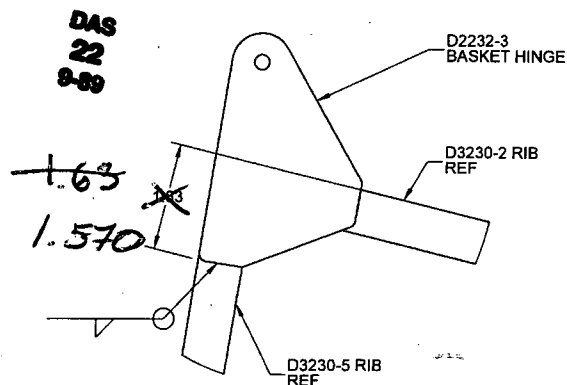
DESIGN	<i>DP</i>	DART AEROSPACE LTD	
DRAWN	<i>DP</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>AS</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>AS</i>	D3230	SHEET 4 OF 5
APPROVED	<i>DP</i>	TITLE	SCALE
DE APPR.	<i>DP</i>	BASKET WEDGE ASSEMBLY	NTS
DATE	09.01.27	COPYRIGHT © 2003 BY DART AEROSPACE LTD	
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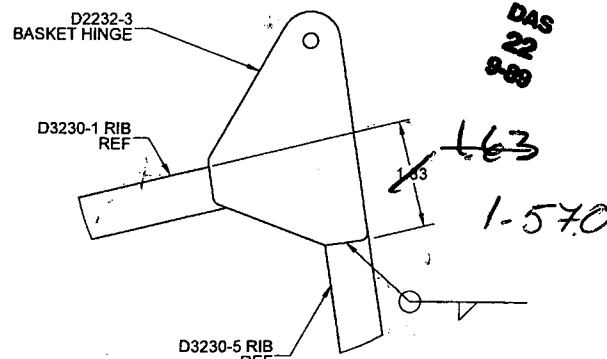
DETAIL C B6-2
MESH NOT SHOWN FOR CLARITY
SCALE 4X



DETAIL D B3-2
MESH NOT SHOWN FOR CLARITY
SCALE 4X



DETAIL E C7-2
MESH NOT SHOWN FOR CLARITY
SCALE 8X



DETAIL F C2-2
MESH NOT SHOWN FOR CLARITY
SCALE 8X

RELEASED
09-21-94

DESIGN	99	DART AEROSPACE LTD	
DRAWN	A	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AJS	DRAWING NO.	REV. C
MFG. APPR.	N	D3230	SHEET 5 OF 5
APPROVED	40	TITLE	SCALE
DE APPR.	41	BASKET WEDGE ASSEMBLY	NTS
DATE	09.01.27	COPYRIGHT © 2003 BY DART AEROSPACE LTD	
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DART SERVICE INSTRUCTION
TO AMEND INSTALLATION INSTRUCTIONS D205-541 REV. J &
INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D205-541 REV. 4
REF. TCCA STC SH96-120,
FAA STC SR00696NY
EASA STC EASA.IM.R.S.01242

Purpose:

The purpose of this DSI is to provide operators of Bell 205/210/212/214/412 Rotorcraft equipped with Dart D205-541-043/-044/-045/-046 Heli-Utility-Baskets with an Upgrade Kit to replace the existing Lid Prop Arm Assembly with an automatic lid opening Gas Spring Kit. On D205-541-043/-044 Baskets, 2 Kits are required (both ends). On D205-541-045/-046 Baskets, ~~a single Kit is required (one end only).~~

Parts List:

both sides, 2 Kits are required

Testing Part

ITEM No.	QTY -051	PART NUMBER	DESCRIPTION
	X	D205-541-051	AUTOMATIC LID OPENER KIT
1	2	D3953-3	GAS SPRING STUD
2	2	D3953-7	GAS SPRING SPACER
3	2	D3953-9	GAS SPRING WASHER
4	3	D3953-17	GAS SPRING SPACER
5	1	D3953-19	GAS SPRING BRACKET
6	1	D3953-21	GAS SPRING BRACKET
8	1	D3969-3	GAS SPRING
9	2	AN3-14A	BOLT
10	2	AN3-20A	BOLT
11	2	AN310-4	CASTELLATED NUT
12	4	MS21042L3	NUT
13	2	MS24665-231	COTTER PIN
14	8	NAS1149F0363P	WASHER
15	2	NAS1149F0463P	WASHER

*20351 → 4x
116051 → 4x
B 118893 → 2x
B 126140 → 2x
B 121441 → 2x
128813 → 4x
117441 → 4x
129913 → 4x
131264 → 8x*

***Note:**

For customers wishing to order new baskets with the Lid Opener pre-installed, use the following numbers:

D205-541-043 BASKET with AUTOMATIC LID OPENER installed = D205-541-043A
D205-541-044 BASKET with AUTOMATIC LID OPENER installed = D205-541-044A
D205-541-045 BASKET with AUTOMATIC LID OPENER installed = D205-541-045A
D205-541-046 BASKET with AUTOMATIC LID OPENER installed = D205-541-046A

PRELIM

CANADA DEPARTMENT OF TRANSPORT AIRCRAFT CERTIFICATION BRANCH DAO #01-O-01	
APPROVED	
BY:	D. SHEPHERD (DE # 02)
DATE:	14.10.31
CERT. NO.:	SH96-120
ISSUE NO.:	3

A	NEW ISSUE		DB	14.10.20
REV.	DESCRIPTION		BY	DATE
DESIGN	DB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	DB			
CHECKED		DRAWING NO.	REV. A	
MFG. APPR.		DSI 9710	SHEET 1 OF 4	
APPROVED		TITLE	AUTOMATIC LID OPENER INSTALLATION	
DE APPR.			SCALE NTS	
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